

CLAIMS

1. A blow molded article obtained by a direct-blow molding process and including a bottom portion (4), a cylindrical body portion (3) arranged above the bottom portion (4), and a cylindrical mouth portion (2) arranged above the body portion (3), wherein said molded article includes at least three pinch-off lines (7) caused by mold-pieces (15) of a split bottom-mold, in a diverging manner from a center of a bottom face (5) at said bottom portion (4).
2. The blow molded article according to claim 1, wherein said pinch-off lines (7) are arranged at substantially equal central angles.
3. The blow molded article according to claim 2, wherein said pinch-off lines (7) comprise four pinch-off lines arranged in a crossed shape.
4. The blow molded article according to claim 1, 2 or 3, wherein said pinch-off lines (7) are formed within a circle which is concentric with said bottom face (5) and which has a diameter less than $\pi D_p/2$, wherein π represents a circular constant and D_p represents an outer diameter of a parison.
5. The blow molded article according to claim 1, 2, 3 or 4, wherein said blow molded article is molded into a container by biaxial-stretching blow molding.
6. The blow molded article according to claim 1, 2, 3, 4, or 5, wherein said blow molded article has a wall in a laminated structure.
7. The blow molded article according to claim 6, wherein said laminated structure is constituted to include, at least, a layer using a polyethylene terephthalate-based resin, and a layer using a polyethylene naphthalate-based resin.
8. The blow molded article according to claim 6, wherein said laminated structure is constituted to include, at least, an outer layer (1a) and an inner layer (1c) both using a polyethylene terephthalate-based resin, and an intermediate layer (1b) using a gas-barrier resin.
9. The blow molded article according to claim 6, wherein said laminated structure is constituted to include, at least, an outer layer (1a)

using polyethylene or polypropylene, and an inner layer (1c) using ethylene-vinylalcohol copolymer or polyethylene terephthalate-based resin.

10. The blow molded article according to claim 6, wherein said laminated structure is constituted to include, at least, an outer layer (1a)
5 using polyethylene or polypropylene, an intermediate layer (1b) using a gas-barrier resin, and an inner layer (1c) using polyethylene or polypropylene.

11. The blow molded article according to claim 6, wherein said laminated structure is constituted to include, at least, an outer layer (1a)
10 and an inner layer (1c) both using a virgin resin material, and an intermediate layer (1b) using a reclaimed resin material.

12. The blow molded article according to claim 6, wherein said laminated structure is constituted to include, at least, an outer layer (1a), and an inner layer (1c) formed of a synthetic resin having a lower
15 compatibility with a synthetic resin forming said outer layer (1a).